

Date: Tuesday, 23/09/2008 10:22:02 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	RH ACTUATOR ASSEMBLY	
Job Number :	42219			
Estimate Number :	12770			
P.O. Number :		Part Number :	41232 200 001 002	
This Issue :	23/09/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	41232-200-001 REV IR	
First Issue :	//	Project Number :	N/A	
Previous Run :	39175	Drawing Revision :	IR	
		Material :		
Written By :		Due Date :	20/10/2008	Qty: 2 Um: Each
Checked & Approved By :	JUL 28.9.23			
Comment :	Est Rev:A New Issue 07-02-28 JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS208224	elbow
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

elbow

Batch: M104427

54

2.0	AN8424D	Elbow
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Elbow

Batch: M108471

54

3.0	41232 200 007 001	Brass Cylinder Assembly
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Brass Cylinder Assembly

Batch: 39219

54

4.0	41232 200 003 001	Spring (Step Actuator)
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Spring (Step Actuator)

Batch: B30941

54

5.0	MS1699623	cap screw
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

cap screw

Batch: M103934

8/10/23

(2x)

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:02 AM
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Job Number: 42219

Part Number: 41232 200 001 002

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN3154R	Nut
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Nut

Batch: M17566

SP

7.0	AN960JD416	Washer
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Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Washer

Batch: M108827

SP

8.0	AN960JD10	Washer
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Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Washer

Batch: M109059

SP

9.0	MS21042L3	Nut
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Nut

Batch: M109031

SP

10.0	AN322A	Bolt
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

Bolt

Batch: M106043

SP

11.0	41232 200 005 003	Spacer (Step Actuator)
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Comment: Qty.: 2 Each(s)/Unit Total : 4 Each(s)

Spacer (Step Actuator)

Batch: B39218

SP

12.0	41232 200 002 005	pivot arm
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Comment: Qty.: 1 Each(s)/Unit Total : 2 Each(s)

pivot arm

Batch: B39217

8/10/2008

(2)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 002 003 latch



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

latch

Batch: B39216

SP

14.0 41232 200 002 001 tube



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

tube

Batch: B42265

SP

15.0 41232 200 008 001 Decal



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

Decal

Batch: B31023

SP

16.0 S 1455 spring-step actuator (replaces 71459)



Comment: Qty.: 1 Each(s)/Unit Total: 2 Each(s)

spring-step actuator (replaces 71459)

BATCH: M104079

8/10/22

2

SP

17.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 08/11/07

2

18.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

~~8/10/22~~

06.11.11 2

19.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 364

8/10/22

2 x SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-11

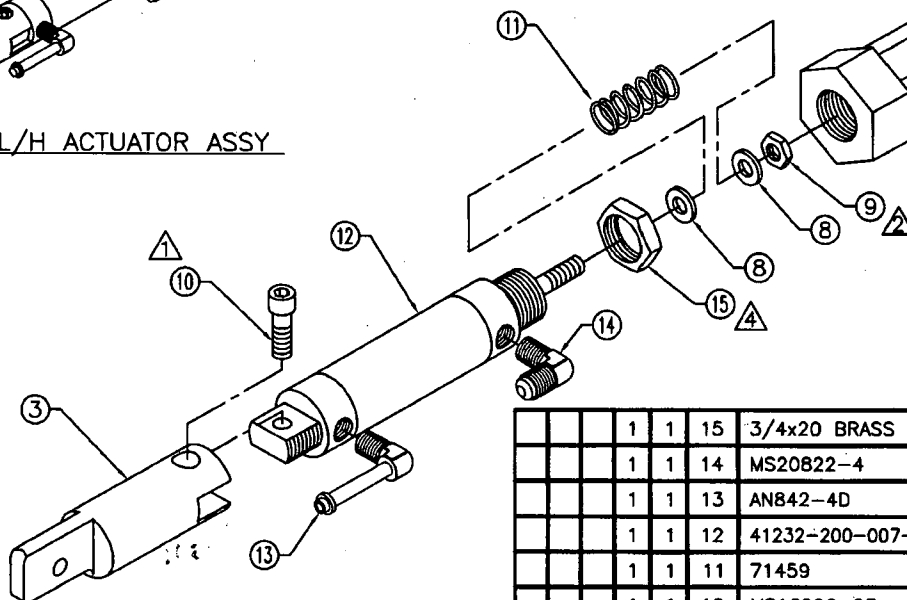
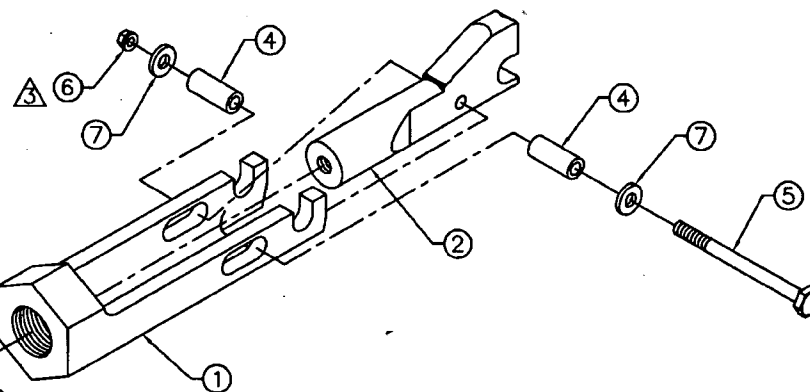
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

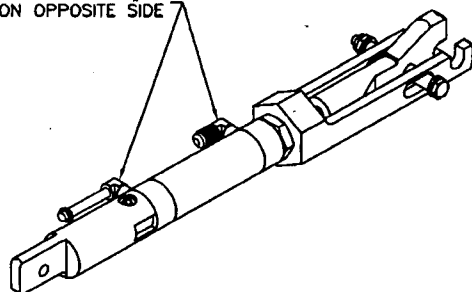
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY-

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43219

			1	1	15	3/4x20 BRASS *	CYLINDER NUT						
			1	1	14	MS20822-4	ELBOW						
			1	1	13	AN842-4D	ELBOW						
			1	1	12	41232-200-007-001	CYLINDER						
			1	1	11	71459	SPRING						
			1	1	10	MS16996-23	CAP SCREW						
			1	1	9	AN315-4R	NUT						
			2	2	8	AN960JD416	WASHER						
			2	2	7	AN960JD10	WASHER						
			1	1	6	MS21042-L3	NUT						
			1	1	5	AN3-22A	BOLT						
			2	2	4	41232-200-005-003	SPACER						
			1	1	3	41232-200-002-005	PIVOT ARM						
			1	1	2	41232-200-002-003	LATCH						
			1	1	1	41232-200-002-001	TUBE						
			/	/		-002	R/H ACTUATOR ASSY						
			/	/		-001	L/H ACTUATOR ASSY						
			-002	-001	FWD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY													
LIST OF MATERIAL													
UNLESS OTHERWISE SPECIFIED X ± .1 XX ± .03 XXX ± .010 ANGLES ± .1/2°													
DRAFTSMAN D. NELSON 5/20/02 TITLE STEP ACTUATOR ASSY													
CHECK D. MURPHY 5/20/02													
STRESS													
PROJ. ENGR.													
HEAT TREAT													
FINISH													
DWG. SIZE C SCALE NONE													
DWG. NO. 41232-200-001 REV IF													
<i>Era Aviation, Inc.</i>													